

**Work Order ID 68671**

Tuesday, April 19, 2011 3:57:23 PM



Page 1

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 4/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 4/19/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9527

rev A

IIN-D206-559

rev K

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

*S. M. 11/14**11-09-14 BG 11-9-14*

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*Sp 11-09-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68671**

Tuesday, April 19, 2011 3:57:23 PM



Page 2

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 4/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Suloz/16

(x4)

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013 Location: 12

Per B

11/9/16 S (4)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/19 J

ME 11-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 19, 2011 3:57:29 PM

Page 1  
3

Work Order ID: 68671



Parent Item: D206-559-013



Parent Item Name: Bearpaw

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:J 04.02.17 Blank size changed KJ/JLM  
 IPP Rev:K 07-01-02 Was K10008 JLM  
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC  
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified  
 By:EC IPP Rev G 10.10.04 per DS19527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A  Bolt		Purchased	No			160	Each	480.0000	12	48			
<div> <div>ST359</div> <div>480</div> </div> <div> <div>116419</div> <div>180</div> </div> <div> <div>116704</div> <div>300</div> </div>													
AN4-20A  Bolt		Purchased	No			160	Each	318.0000	12	48			
<div> <div>ST359</div> <div>318</div> </div> <div> <div>115936</div> <div>118</div> </div> <div> <div>116419</div> <div>200</div> </div>													
AN960JD416  Washer	NAS1149D0463J	Purchased	No			160	Each	0.0000	24	96			

SP 11-09-15

48x

SP 11-09-18

26x  
22x

SP 11-09-18

m 118384 96x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 19, 2011 3:57:30 PM

Page 2

Work Order ID: 68671

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

D2182B Manufactured No 160 f 347.3169 2.5 10



Rubber Cushion



8P 11-09-15

Location

Loc Qty

Loc Code

ST410

347.3169

66063

347.3169

10

(D2182B050) cut qty (6) at 5.00" as per dwg \*\*\*per kit\*\*\*

D2274 Manufactured No 160 Each 528.0000 12 48



Radius Block



8P 11-09-15

Location

Loc Qty

Loc Code

ST010

528

65757

124

67578

404

B 69773 33X  
B 69736 15X

D2432 Manufactured No 160 Each 1.0000 2 8



206 (24") Bearpaw



8P 11-09-14

Location

Loc Qty

Loc Code

ST495

1

65302

1

B 72356 (8X)

D2438 Manufactured No 160 Each 117.0000 6 24



Clamp



8P 11-09-15

Location

Loc Qty

Loc Code

ST456

117

66064

44

67830

73

B 68673 15X  
B 70693 9X

Tuesday, April 19, 2011 3:57:30 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, April 19, 2011 3:57:30 PM

Page 3

Work Order ID: 68671

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

D2529 Manufactured No 160 Each 641.0000 12 48



Washer



SP 11-09-15

Location

Loc Qty

Loc Code

ST016

641

64127

141

66953

500

48

D2732 Manufactured No 160 f 323.5000 2.5 10



Rubber Extrusion



SP 11-09-15

Location

Loc Qty

Loc Code

ST410

323.5

64283

323.5

10

(D2732-050) cut qty (6) at 5.00" as per dwg \*\*\*per kit\*\*\*

MS21042L4 Purchased No 160 Each 5,442.000 12 48



Nut



SP 11-09-15

Location

Loc Qty

Loc Code

ST300

5442

116188

442

116823

2000

117441

3000

m 117885 48x

Tuesday, April 19, 2011 3:57:30 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# REFERENCE ONLY

DART AEROSPACE LTD.

D206-559  
Page 7 of 13

## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

• COPYRIGHT © 1990 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: L  
Date: 11.04.08